

# ABSTRACT OF THE DISCLOSURE

When drilling a multi layered sheet-like material,  
drilling is first made with pulses having energy that  
5 generates an inter-layer pull-off force smaller than the  
adhesion force between the layers. Then pulses with higher  
energy are radiated for trimming the shape of the holes, and  
thus through-holes having a desired shape are drilled without  
causing delamination of the layers.

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